Date: Thursday, 3/8/2007 12:36:09 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: MIRROR ARM
Job Number	: 31100		
Estimate Number	: 10335		
P.O. Number	: N/A	**Part Number**	: D2010104
This Issue	: 3/8/2007 **S.O. No.** : N/A	**Drawing Number**	: D2010 REV. C2
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : SMALL /MED FAB	**Drawing Revision**	: C2
Previous Run	: 29772	**Material**	: N/A
Written By	:	**Due Date**	: 3/30/2007 **Qty:** ~~10~~ 11 **Um:** Each
Checked & Approved By	: KJ 07,03,08		
Comment	: Est A 04.02.17 New issue KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W

Comment: Qty.: 1.5750 f(s)/Unit Total : 15.7500 f(s)
Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall
(M304TR0500W035) Batch No: M103869 x 4mx. M103453 x 7m / M102742 x 3

FF 07-03-15 1Φ

2.0 BRAKE NC — NC BRAKE

Comment: BRAKE NC
Punch per Dwg. D2010-104 and Spec Control Dwg D2727
Identify as D2010-104

FF 07-03-15 2Φ

3.0 SMALL FAB 1 — SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Bend as per Dwg D2010 using bending Jig D2010-104T2
2- Deburr

MF 07-05-03 (10)

4.0 D2057 — Plug

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Plug

B 22655 - MF07-05-03

5.0 SMALL FAB 1 — SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Install D2057 plug as per Dwg D2010

MF 07-05-07 (11)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** EP **Date:** 07/05/16

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
07/04/17	1	3 piece were not good wrong material 1049 was 1035	QS1042	Scrap + destroy	SB 07/04/17	07/04/17	QS1042	07/04/17

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 12:36:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** MIRROR ARM

Job Number: 31100 **Part Number:** D2010104

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	JB 07/05/07 (11)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	M102316 (11X) M.L 07/05/15
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	Cu 7/05/16 (11)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	Cu 7/05/16 (11)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(11) JB 07/05/16

Job Completion

U 07-05-16

Dart Aerospace Ltd

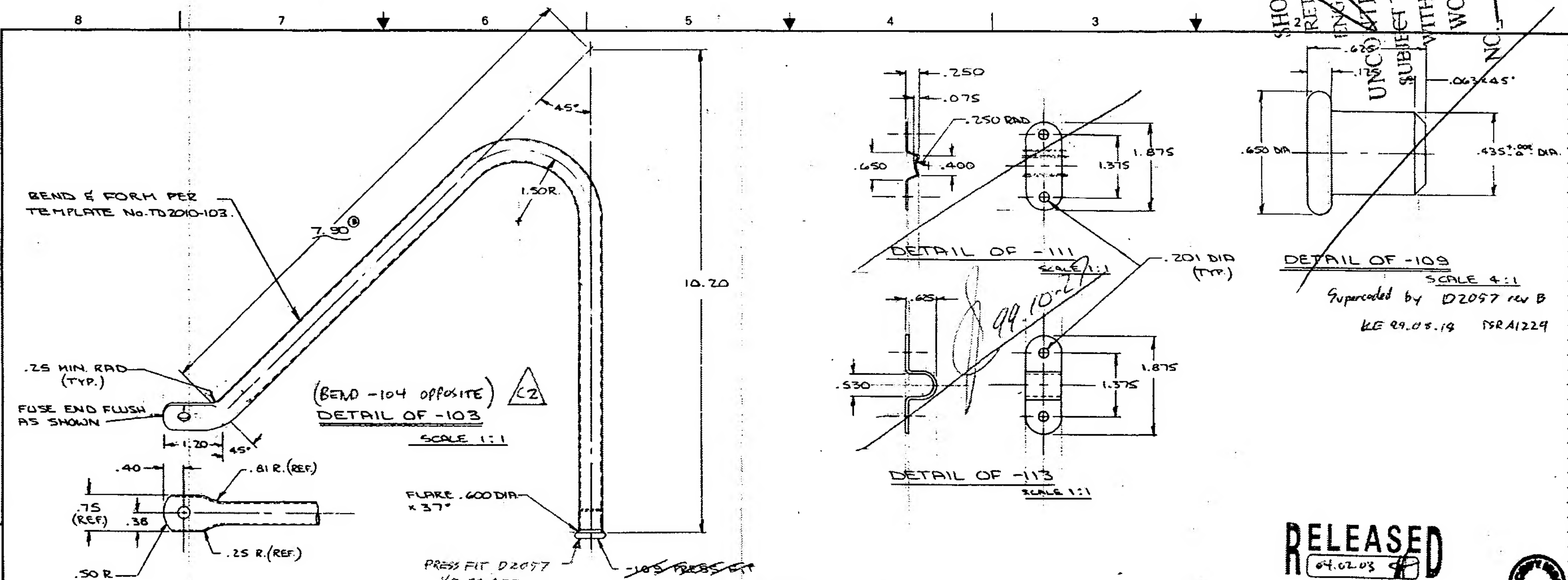
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

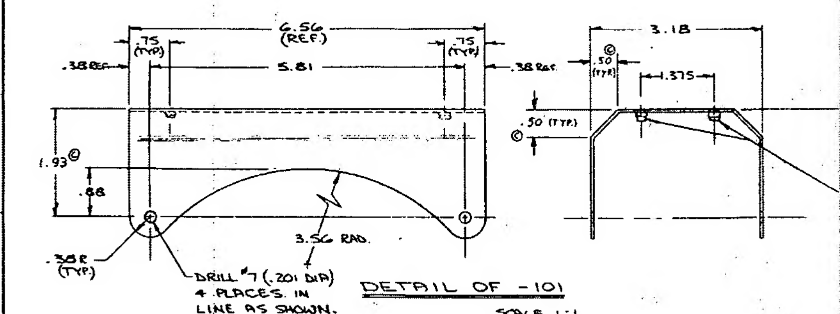
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries


BEND & FORM PER TEMPLATE No. TD2010-103.
7.90
45°
1.50R.
10.20
.25 MIN. RAD (TYP.)
FUSE END FLUSH AS SHOWN
1.20
45°
(BEND -104 OPPOSITE)
DETAIL OF -103
SCALE 1:1
.40
.81 R. (REF.)
.75 (REF.)
.38
.50 R
.25 R. (REF.)
FLARE .600 DIA x 37°
PRESS FIT D2057
KE 99.10.27
-105 PRESS FIT
.250
.075
.250 RAD
.650
.400
1.875
1.375
DETAIL OF -111
SCALE 1:1
.201 DIA (TYP.)
.625
.530
1.875
1.375
DETAIL OF -113
SCALE 1:1
99.10.27
.625
.125
.063 x 45°
.650 DIA
.435 DIA.
DETAIL OF -109
SCALE 4:1
Superceded by D2057 rev B
KE 99.08.18 TSR A1229



GENERAL NOTES:

1. BEND RADIUS FOR 2024-T3 .063 THICK IS .188
2. PAINT -101 MATTE BLACK.
3. TYPE 304 STAINLESS STEEL MAY BE SUBSTITUTED WITH TYPES 303 OR 316.
4. 2024-T3 MAY BE SUBSTITUTED WITH 2024-T3 CLAD (QQ-A-250/5).

-103 FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 (C2)

FE-032-EF (QTY 4) INSTALL PER PEM INSTALLATION INSTRUCTIONS.

QTY. REQUIRED -103	QTY. REQUIRED -101	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	4	FE-032-EF		FASTENER		PEM
		D 2010-113		CLAMP	.050 THICK (3)	AISI 304
		D 2010-111		SADDLE	.025 THICK (3)	AISI 304
1		D 2010-109		PLUG	6061-T6 BAR	QQ-A-225/6
X		D 2010-103		ARM	CRES TUBE .50 DIA x .035 W	AISI 304
	X	D 2010-101		BRACKET	2024-T3 .063 THK	QQ-A-250/4 (4)

REV.	C2	C1	C	B	A
DRAWN					BRADLEY 30.03.31
APPROVED	04.01.29	02.05.25			
DESCRIPTION OF CHANGE	ADD FINISH				

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REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

RIVET CODE SHALL BE PER NAS 523

REPORT ALL DISCREPANCIES — DO NOT SCALE

EFFECTIVITY

DART — DART AERO ACCESSORIES INC, VANCOUVER, CANADA

DRAWN	BRADLEY	30.03.31
DESIGN	BRADLEY	30.03.31
STRESS		
CHECKED		
CLIENT		

TITLE: MIRROR BRACKET DETAILS

DWG NO: D2010 — REV. C

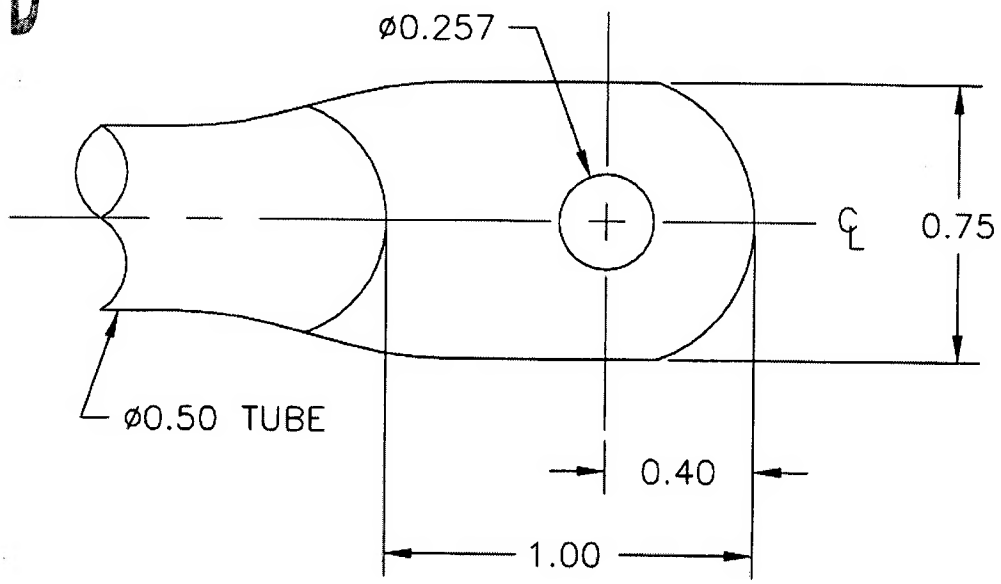
SCALE: NOTED — SHT 1 OF 1

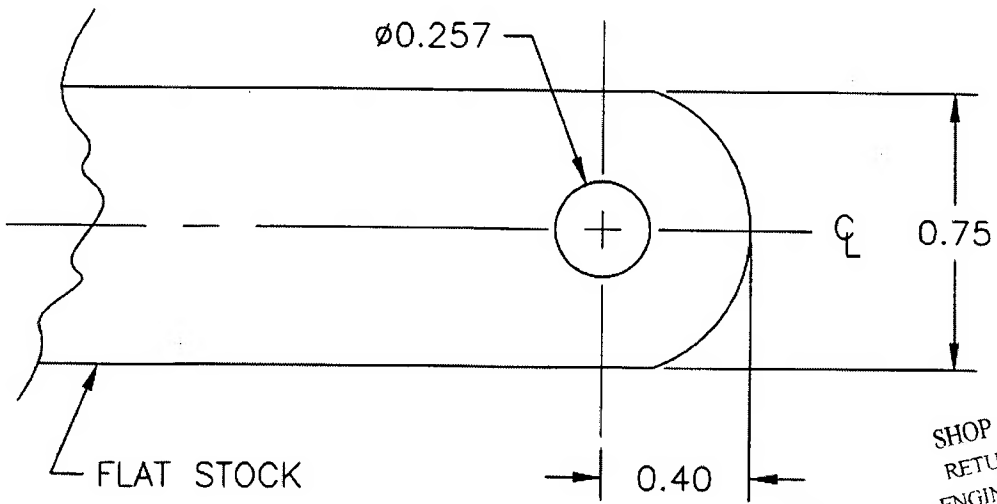
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
KE	KE		
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2727	SHEET 1 OF 1
DATE		TITLE	SCALE
97.11.24		PUNCH DT8012 SPEC CONTROL	2:1

A	97.11.24	NEW ISSUE
A1	01.12.20	ADD TOLERANCE NOTE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE





NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED. A1

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